



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6205G13231-3G

Job Sheet 177008



DAS
13
9-89

Part No: RBW6205G13231-3G

Job Qty: 3 ea

Part Name: Arm Assembly

MAY 6 7 2018



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/4/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13231-3G REV 1 IPP REV A 18.02.16 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		6/8/18	0.00	0.00	Start Up Container		
100	Purchasing	3 pcs		6/8/18	0.00	0.00	Purchasing		At 19/06/07
110	Packaging	3 pcs		6/8/18	0.00	0.00	Packaging2		At 19/06/07
120	QC	3 pcs		6/8/18	0.00	0.00	QC6		At 19/06/07
130	Packaging	3 pcs		6/8/18	0.00	0.00	Packaging3		At 19/06/07
140	QC21-SA	3 Ea		6/8/18	0.00	0.00	QC21		At 19/06/07

Part Op 100 - 1- Issue P/O to Arrow Tech Machine Works P/O# 039626. 2- Manufacture RBW6205G13231-3G as per Descriptions: DWG 3- Certificate of conformity is required

08 Mar 2018 x 6 R h

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G13231-3GP	Arm Assembly	3 Ea (1 ea)	90-Start up Operation	5078952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G13231-3GP	3	0	0

Part Specifications

Specifications could not be found.

Plex 5/4/18 10:44 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

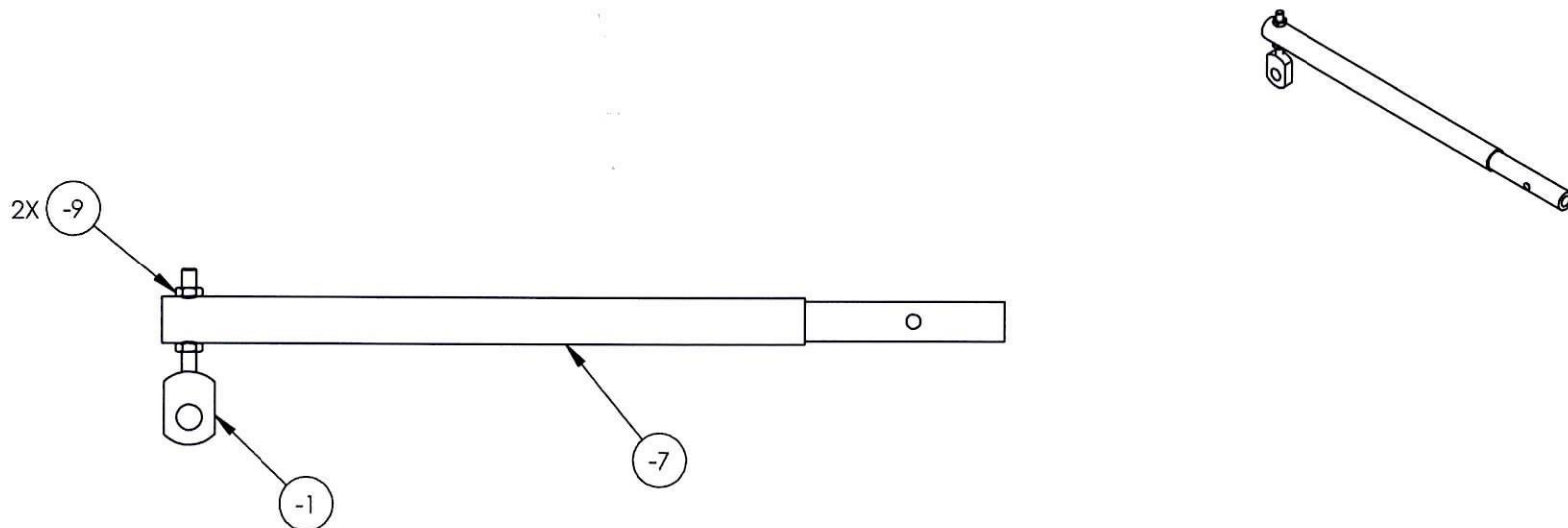
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																							
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																					
Description Work Order Deviation			Disposition																																																																						
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S078998 Part: RBW6205G13231 - 3G Job No: 177008 Serial No/Batch: S078998 Revision: 1 Inspector: Exp Date: 06/07/2018 Instructions: Date: 06/07/18					Completed By																																																																				
					Lead hand / Supervisor Approval Verification																																																																				
					QC / QA Coordinator Approval																																																																				
Root Cause <table style="width:100%;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table>			Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	<table style="width:100%;"> <tr><td>☐</td><td>Positioned Wrong</td></tr> <tr><td>☐</td><td>Outside Dimensions</td></tr> <tr><td>☐</td><td>Over/Under tolerance</td></tr> <tr><td>☐</td><td>Part Incorrect</td></tr> <tr><td>☐</td><td>Part Lost/Missing</td></tr> <tr><td>☐</td><td>Part Moved</td></tr> <tr><td>☐</td><td>Drawing</td></tr> <tr><td>☐</td><td>Finish</td></tr> <tr><td>☐</td><td>Misread</td></tr> <tr><td>☐</td><td>Turning Sequence</td></tr> </table>			☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 DELETED ENGRAVE NOTE. -3 ADDED ENGRAVE NOTE. -7 ADDED ENGRAVE NOTE. -9 CH'D WAS 5/16-18 #93839A030 IS 5/16-24 UNF #93839A810.	1/19/2011	RJC	RW
B		-3 CH'D ENGRAVE NOTE WAS RBW6205G13451 IS RBW6205G13231-3G.	4/15/2013	CF5	RW
1	15-0152	-1 CH'D QTY WAS 3 IS 1. CH'D WELD WAS SILVER SOLDER IS TIG. CH'D MATERIAL CALL OUT WAS 1018 IS 1018/1020. -7 CH'D DIM WAS Ø.500 IS Ø.50.	7/1/2015	RJC	JAG



NOTES:

1. REF. AGUSTA T/N: 3G6205G13231-3G.
2. PART OF KITS RBW6205G11231-3G AND RBW6205G13831-3G.

DART AEROSPACE	
TITLE ARM ASSEMBLY	
DWG NO. RBW6205G13231-3G	REV 1
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED <i>D Weel</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:4	DATE 4/30/2010 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	ADJUSTER WELDMENT			2
	1		-3		LINK	1018/1020		3
	1		-5		STUD	STEEL	5/16-24 (MCMASTER-CARR #98791A030) MODIFIED	4
			-7	1	TUBE	6061		5
		B/O	-9	2	THIN HEX NUT	STEEL	5-16-24 UNF (MCMASTER-CARR #93839A810)	1
ASSY #	ASSY #							
	-1							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039826

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO039826

PO Date: 5/8/18

Due Date: 6/4/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lussier, Patrick

Pynt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
MAY 07 2018

Ship To:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RBW6205G11451-3GP	Clamp As Per Dwg RBW6205G11451-3G Rev. 1	Firmed	6/4/18	16 Ea	0 Ea	16 Ea	\$83.64/Ea	\$1,338.24
Line Item Note W/O 177012										
2		RBW6205G13231-3GP	Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	6/4/18	6 Ea	0 Ea	6 Ea	\$413.50/Ea	\$2,481.00
Line Item Note W/O 177008										
3		RBW6205G12731-3GP	Upper Plate Assembly As Per Dwg RBW6205G12731-3G Rev. 3	Firmed	6/4/18	2 Ea	0 Ea	2 Ea	\$2,595.37/Ea	\$5,190.74
Line Item Note W/O 177007										

Grand Total: \$9,009.98

Order Notes

red 11/4/16/07

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

[Signature]

Plex 5/8/18 11:39 AM dart.Lussier.Patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:039826

Dated: 6/5/2018

Our Order / Job No:039826-1AWT

Order Qty: 6

Part Name: ARM ASSEMBLY

Part Number: RBW6205G13231-3G

Lot Size:N/A

Ship Date: 6/5/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RBW6205G13231-3G

Rev:1

Material Size and Type: -3/1018 STEEL; -7/6061 ALUM.

Material Specifications: STEEL: ASTM A108, ASTM A29; ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS I; ZINC PLATE: ASTM B633 TYPE 1, SC2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 6/5/18

Signed: Hemat-m fahd

DA:
38
9-85

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com